a separation unit mounting a metal cutter, said second support having ancillary under-supports disposed laterally to either side of said metal cutter and engagable with an underside of said elongated metallic workpiece, and means to constrain lateral movement of said workpiece passing through said separation unit, said separation unit having at least one pair of horizontally spaced apart non-driven guide rollers adjacent said metal cutter, each guide roller of said pair being freely rotatable about a substantially vertical axis and spaced laterally to a respective side of said metal cutter, said constraint means providing no lateral constraint of movement of said workpiece downstream of a most downstream pair of said non-driven guide rollers;

said first workpiece support including an elongate conveyor table comprising a plurality of horizontally disposed rollers, and said third workpiece support surface including a receiving table arranged to receive and support fully separated workpieces issuing from said separation unit, wherein the width of said receiving table is substantially greater than the width of said second workpiece support surface; and

a feeder comprising:

a pusher upstream of said cutter and adjacent said elongate conveyor table, said feeder movable between respective distal ends of said elongate conveyor table in a substantially horizontal plane by a linear driver; and

a conveyor table downstream of said cuter, said conveyor table having a plurality of horizontally disposed driven rollers;

said first and third workpiece supports extensible in substantially a common horizontal plane and said second support movable in a direction substantially perpendicular to said common horizontal plane.

52. A process for separating a cold elongated metallic workpiece along a substantially longitudinal axis thereof into two separate sections, said process comprising the steps of:

providing a separation unit comprising:

separate first, second and third spaced apart workpiece supports, said first and third workpiece supports extending upstream and downstream respectively of said second workpiece support;

a separation unit mounting a metal cutter, said second support having ancillary under-supports disposed laterally to either side of said metal cutter and engagable with an underside of said elongated metallic workpiece, and means to constrain lateral movement of said workpiece passing through said separation unit, said separation unit having at least one pair of horizontally spaced apart non-driven guide rollers adjacent said metal cutter, each guide roller of said pair being freely rotatable about a substantially vertical axis and spaced laterally to a respective side of said metal cutter, said constraint means providing no lateral constraint of movement of said workpiece downstream of a most downstream pair of said non-driven guide rollers;

said first workpiece support including an elongate conveyor table comprising a plurality of horizontally disposed rollers, and said third workpiece support surface including a receiving table arranged to receive and support fully separated workpieces issuing from said separation unit, wherein the width of said receiving table is substantially greater than the width of said second workpiece support surface;

a feeder comprising:

a pusher upstream of said cutter and adjacent said elongate conveyor table, said feeder movable between respective distal ends of said elongate conveyor table in a substantially horizontal plane by a linear driver;

a conveyor table downstream of said cuter, said conveyor table having a plurality of horizontally disposed driven rollers;

said first and third workpiece supports extensible in substantially a common horizontal plane and said second support movable in a direction substantially perpendicular to said common horizontal plane;

placing said elongated metallic workpiece on said separation unit;

aligning said substantially longitudinal axis of said elongated workpiece with said cutter of said separation unit;

feeding said elongated workpiece through said separation unit to cut said separate sections;

supporting said separated sections; and

constraining lateral movement of said elongated workpiece in said separation unit.